

Job Number: 40608

Part Number: PB674300115

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

See 08/14/12

21.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *Seq*

8/9/12

2x

SP

22.0

QC21

FINAL INSPECTION/W/O RELEASE



08/09/15

Comment: FINAL INSPECTION/W/O RELEASE

MF 08-09-12

Job Completion



Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD ADJUSTABLE BLADE SUPPORT ASSY

Job Number: 40608

Part Number: PB674300115

Job Number:



Seq. #:

Machine Or Operation:

Description:

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

1:40 OF
320
2:10

M-A 08/27/31 (52)

14.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FD 08/27/31 (5)

15.0

PB674300173

20 Degree Cover Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

20 Degree Cover Plate

batch: 40094

14 08-08-24

16.0

PB674300183

PB67-43001-83



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

PB67-43001-83

batch: 40096

14 08-08-24

17.0

MS27039110

Screw



Comment: Qty.: 8.0000 Each(s)/Unit Total: 40.0000 Each(s)

Screw

batch: 108986

14 08-08-24

18.0

NAS1149F0316P

WASHER



Comment: Qty.: 8.0000 Each(s)/Unit Total: 40.0000 Each(s)

WASHER

batch: 108473

14 08-08-24

19.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- match drill cover to existing holes in support

2- assemble as per dwg

14 08-08-24

ay, 24/07/2008 8:23:49 AM
anie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD ADJUSTABLE BLADE SUPPORT ASSY

Job Number: 40608

Part Number: PB674300115

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1- make a 0.090" chamfer in the 1.00" hole before welding

2- assemble parts and weld as per dwg

Handwritten: 08-07-24

7.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

Handwritten: 08-01-27

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Handwritten: 08-07-24

9.0

MS124780

HELICAL INSERT



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

HELICAL INSERT

Handwritten: M 17935

Handwritten: 08-07-24

10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- grind weld flush in area of PB67-43001-249 only

2- tap drill for helicol

3- install helicol insert as per dwg

Handwritten: BK 08-07-30

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Handwritten: 08-07-24

12.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

13.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Handwritten: M102316

Handwritten: 5X

1- MASK TUBE FROM BASE TO GUSSET

2- Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

Handwritten: M-1

Handwritten: 08/07/31

Process Sheet

Duplex

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 40608 -1A
Estimate Number : 13433
P.O. Number :
This Issue : 24/07/2008 S.O. No. :
Prsht Rev. : NC
First Issue : 17/07/2008 Type : LARGE FAB ASSY
Previous Run :
Written By :
Checked & Approved By : MF 08-07-24
Comment : Est Rev:A 08-06-26 new issue DD verified by:ec

Drawing Name : FWD ADJUSTABLE BLADE SUPPORT ASSY
Part Number : PB674300115
Drawing Number : B6743001 P.7
Project Number : N/A
Drawing Revision : B1
Material :
Due Date : 24/07/2008
Qty: 35 Um: E2

2

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 PB6743001257 Inner Tube



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)
Inner Tube
batch: 40585

08-07-24

2.0 PB6743001249 Inner Tube Bushing



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)
Inner Tube Bushing
batch: 112141

08-07-24

3.0 PB6743001253 Gusset



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)
Gusset
batch: 340045

08-07-24

4.0 PB6743001254 Gusset



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)
Gusset
batch: 340053

08-07-24

5.0 PB674300171 PB67-43001-71



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)
PB67-43001-71
batch: 340027

08-07-24